

Date: Thursday, 22/01/2009 7:51:50 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER BLADE SUPPORT ASSY
Job Number	: 45010		
Estimate Number	: 13471		
P.O. Number	:	Part Number	: PB674300175
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.11
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 43001	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 16 Um: Each
Checked & Approved By	: <u>mf 09-01-22</u>		
Comment	: Est Rev:A 08-07-17 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001167	Long Side Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Long Side Plate

batch: 41561

mf 09-01-27

2.0	PB6743001169	Long Support Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Long Support Plate

batch: 41209 x 11, 41562 x 5

mf 09-01-27

3.0	PB6743001171	Mounting Plate
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 96.0000 Each(s)

Mounting Plate

batch: B 41563

mf 09-01-27

4.0	D34501	Reinforcement Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Reinforcement Plate

batch: B 41554

mf 09-01-27

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: Weld assembly as per dwg PB67-43001

SP 09.02.04

(16x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:51:50 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER BLADE SUPPORT ASSY

Job Number: 45010

Part Number: PB674300175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-04 (16)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09/02/04 (16)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M1023/6

1- put screws in nut plates before powder coating to keep thread clean

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

PR / MD 09/02/05 (16)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CE 9/2/06 (16)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CE 9/2/06 (16)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/09 (16)

Job Completion



MF 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

RELEASED
06 01-20

MS21075L3 NUTPLATE
MS20426AD3-4 7:1VET (2)
6 PL 1A

1.00
4.00 REF
1.50

-169 2 PL 1A

-171 6 PL 1A

-167 2 PL 1A

2.59 REF
2 PL

9.31 2 PL
9.31 2 PL
.50 REF
1.38
25.75 REF

0 0
D3450-1

MS21075L3 NUTPLATE
MS20426AD3-4 7:1VET (2)
6 PL 1A

1.00
4.00 REF
1.50

-171 6 PL 1A

-179 2 PL 1A

8.45 2 PL
9.20 2 PL
.50 REF
.59 REF
1.30
24.25 REF
24.50 REF

② -75 UPPER BLADE SUPPORT ASSEMBLY 1/8" SCALE 0.500

45010

② -79 LOWER BLADE SUPPORT ASSEMBLY 1/8" SCALE 0.500

PREMIER AVIATION, INC.
8000 Aviation Parkway, Grand Prairie, Texas 75052
AVAL 1001 (REV) NO. 00000000
D OSUV8 867-43001 REV
SCALE: 1"=1' SHEET 11 OF 45

ORIGINAL